

Work Order ID 50931

July 27, 2009 9:52:40 AM

Page 1

Item ID: D3688-7

Accept

Revision ID: B

Item Name: STUD

Setup Start

Stop

Start Date: 7/27/09 Start Qty: 10.00

Required Date: 8/07/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3688

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

DQ NOT USE CHOP SAW*

☐ Cut blank 9.724" long

08.08.12 (10)

110

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA729 Rev: 16 & Dwg D3688 Rev: 16 ☐ 2-Deburr
per dwg D3688

08.08.12

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

09.08.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3688-7 PAR #: JA Fault Category: Machine NCR: (Yes) No DQA: W Date: 09.08.20
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: W Date: 09.08.27

NCR: <u>50931</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09.08.19</u>	<u>110</u>	<u>Drill failure inside workpiece (x1). Unable to complete thread. Threading tool lost orientation slightly because of unknown reason. Probly to do w/ backlock (x2)</u>	<u>[Signature]</u>	<u>Scrap + rep don't replace one. Scrap + salvage the other for mat'l. Tried to fix thread w/ thread die but didn't work</u>	<u>[Signature]</u> <u>09.08.19</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>09.08.19</u>
		<u>R.C. Machine Mate function.</u>						

NOTE: Date & initial all entries

Work Order ID 50931

July 27, 2009 9:52:40 AM



Page 2

Item ID: D3688-7

Accept



Setup Start



Revision ID: B

Stop



Item Name: STUD

Start Date: 7/27/09

Start Qty: 10.00



Cust Item ID:

Required Date: 8/07/09

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



CONVENTIONAL LATHE

Lathe Conv

Memo

0.00

Conventional Lathe

Face to finished length as per dwg D3688 AND center drill as per Dwg D3688

RF 09.08.13

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

RF 09.08.13

150

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA718 Rev: 13 & Dwg D3688 Rev: 16 □2-Deburr
per dwg D3688

RF 09.08.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50931

July 27, 2009 9:52:40 AM



Page 3

Item ID: D3688-7

Accept



Setup Start



Revision ID: B

Stop



Item Name: STUD

Start Date: 7/27/09

Start Qty: 10.00



Cust Item ID:

Required Date: 8/07/09

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 07.08.13 (8)

170

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SA 07/08/19 (7)

180

PURCHASING

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 10220 [] LPI Per ASTM 1417 LEVEL
2 [] Certificate of conformaty is required

CZ 09/08/19 (10)

210

Identify as per dwg & Stock Location: 111

0.00



Packaging

Memo

0.00

Packaging

9/8/19 (10) Sp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 27, 2009 9:52:39 AM

Work Order ID: 50931

Parent Item: D3688-7RevB

Parent Item Name: STUD

Comments:

Start Date: 7/27/09

Required Date: 8/07/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174PH-H900R1.000		Purchased	No			100	f	64.5000	11.4432			



17-4SS H900 ROUND BAR 1.00

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

64.5

110213

3.3

110750

24.99

110990

11.87

111055

24.34

M112374

11' 11" 09.08.13

DART AEROSPACE LTD		Work Order:	50931
Description: Stud		Part Number:	D3688-7
Inspection Dwg: D3688 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.508	+/-0.010	.508	/			
0.438	+0.004/-0.000	.439	/			
1.42	+0.000/-0.03	1.41	/			
118°	0.5°	118°	/			
R0.03	+/-0.030	R.03	/			
0.07 Ref	+/-0.030	.07	/			
90°	0.5°	90°	/			
Ø0.189	+0.005/-0.001	.181	/			
1.025	+0.000/-0.010	1.020	/			
Ø0.659	+0.000/-0.015	.651	/			
9.624	+/-0.015	9.630	/			
2.90	+/-0.030	2.9	/			
3/4-16UNF-2A	N/A	2A	/			
0.075 x 45°	+/-0.010 x 0.5°	.075	/			
0.445	+0.000/-0.010	.440	/			
Ø0.189	+0.005/-0.001	.191	/			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 09-08-19	Date: 09/08/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

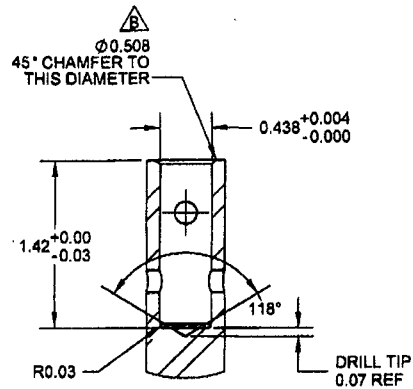
0465

978
3785

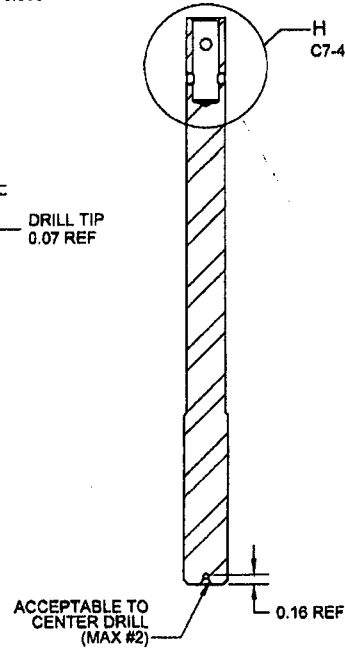
095

930

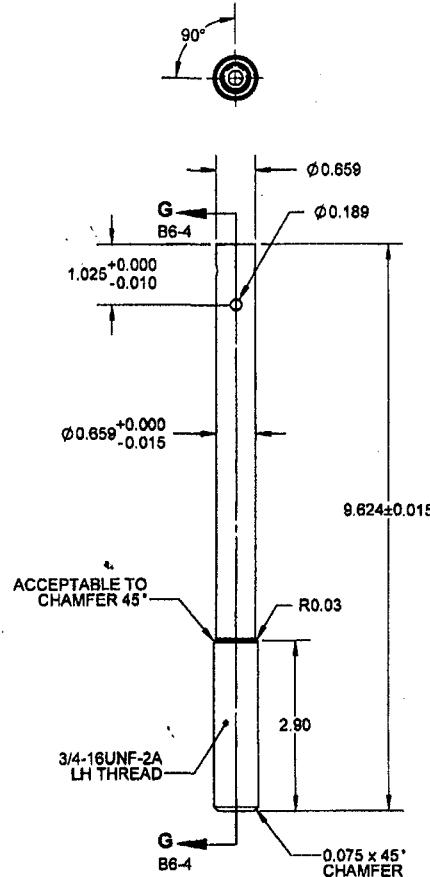
350



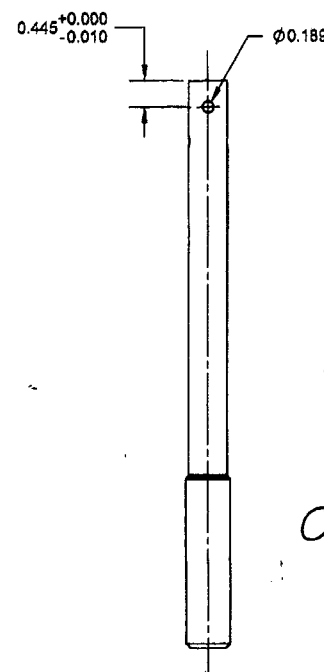
DETAIL H
SCALE 2X
D6-4



SECTION G-G
D4-4



D3688-7 STUD



50931
OK MD 8/10/12
UNDER REVIEW
8/12/12 MD
CHANGE CENTER
DRILL TO #4

RELEASE
8/12/12 MD

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.97 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	92	DRAWING NO.	REV. B
MFG. APPR.	92	D3688	SHEET 4 OF 4
APPROVED	92	TITLE	SCALE
DE APPR.	92	STUD	NTS
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